

1 CLAIMS

- SWAT 1. A method for forming a cylindrical cutting element body of a predetermined diameter having a canted end surface, the method comprising the steps of:
- 5 forming a cylindrical work piece having a central axis and a diameter twice the predetermined diameter and a convex protrusion extending from an end of the cylindrical work piece; and
- cutting the cylindrical body from the cylindrical work piece such that the outer surface of the cylindrical body is cut tangent to the outer surface of the cylindrical work piece.
- 10 2. A method as recited in claim 1 further comprising the step of cutting a second cylindrical body from the cylindrical work piece wherein the outer surface of the second cylindrical body is cut tangent to the outer surface of the cylindrical work piece.
- 15 3. A method as recited in claim 2 wherein the step of cutting a second cylindrical body comprises the step of cutting a second cylindrical body tangent to the first cylindrical body at the central axis of the work piece.
- 20 4. A method for forming a cylindrical cutting element body of a predetermined diameter having a canted end surface, the method comprising the steps of:
- forming a cylindrical work piece having a cylindrical outer surface and a longitudinal central axis and a diameter at least twice the predetermined diameter and a convex protrusion extending from an end of the cylindrical work piece; and
- 25 cutting the cylindrical body from the cylindrical work piece, wherein cylindrical body comprises a longitudinal central axis the central axis, wherein the longitudinal central axis of the workpiece is offset from the longitudinal central axis of the cylindrical body.
- 30 5. A method as recited in claim 4 further comprising the step of cutting a second cylindrical body from the cylindrical work piece wherein the second cylindrical body comprises a longitudinal central axis offset from the longitudinal central axis of the work piece.
- 35 6. A method as recited in claim 5 wherein the step of cutting a second cylindrical body comprises the step of cutting a second cylindrical body tangent to the first cylindrical body at the central axis of the work piece.

1 *SP A17* 7. ~~A method as recited in claim 4 wherein the step of cutting the first cylindrical body comprises the step of cutting the first cylindrical body having a cylindrical outer surface tangent to the outer cylindrical outer surface of the workpiece.~~

5 8. A method as recited in claim 7 further comprising the step of cutting a second cylindrical body from the cylindrical work piece, wherein the second cylindrical body comprises a longitudinal central axis offset from the central longitudinal axis of the workpiece and wherein the second cylindrical body outer surface is ~~tangent to workpiece cylindrical outer surface.~~

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